

Date: Monday, 27/04/2009 8:35:27 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TURNING DETAIL FOR D2893-1
<b>Job Number</b> : 47481	
<b>Estimate Number</b> : 13234	
<b>P.O. Number</b> :	<b>Part Number</b> : DSK078
<b>This Issue</b> : 27/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : DSK078 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 47395	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/05/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> <i>JLD 090427</i>	
<b>Comment</b> : est rev A. 08.03.13 new issue EC	
Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6104005	Round Billet, 17-4
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 Support *Batch: B47478*

*ml 09/05/11*

(10)

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE  
 Turn blank as per Folio FA081

*ml 09/05/11*

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 09/05/11*

(10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*SA 09/05/11*

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: \_\_\_\_\_

*ml 09/05/11*

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 27/04/2009 8:35:27 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 47481

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries


<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 4748
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b> DSK078
<b>Inspection Dwg:</b> DSK078	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.712	2.708	2.711	2.711
B	4.946	4.966		4.957	4.957	4.957	4.957	4.960
C	3.064	3.084		3.076	3.075	3.076	3.076	3.076
D	0.718	0.738		.725	.725	.724	.726	.725
E	0.090	0.110		.102	.102	.103	.103	.102
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.175	2.175	2.171	2.171	2.172
H	3.890	3.910		3.901	3.901	3.901	3.902	3.901
I	0.914	0.934		.925	.925	.926	.925	.925
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.118	.117	.118	.117	.117
L								
M								
N								
O								
P								

**Measured by:** 
**Date:** 09/10/11

**Audited by:** 
**Date:** 09/05/11

**Prototype Approval:**
**Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47481
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b> DSK078
<b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article      ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.709	2.709	2.709
B	4.946	4.966		4.959	4.955	4.956	4.959	4.959
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.726	.726	.725	.725	.726
E	0.090	0.110		.102	.102	.103	.103	.103
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.170	2.170	2.173	2.173	2.173
H	3.890	3.910		3.902	3.901	3.901	3.901	3.901
I	0.914	0.934		.925	.922	.926	.926	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.116	.117	.117	.118	.116
L								
M								
N								
O								
P								

**Measured by:** *mf*      **Date:** 09/05/11

**Audited by:** *SAC*      **Date:** 09/05/11

**Prototype Approval:**      **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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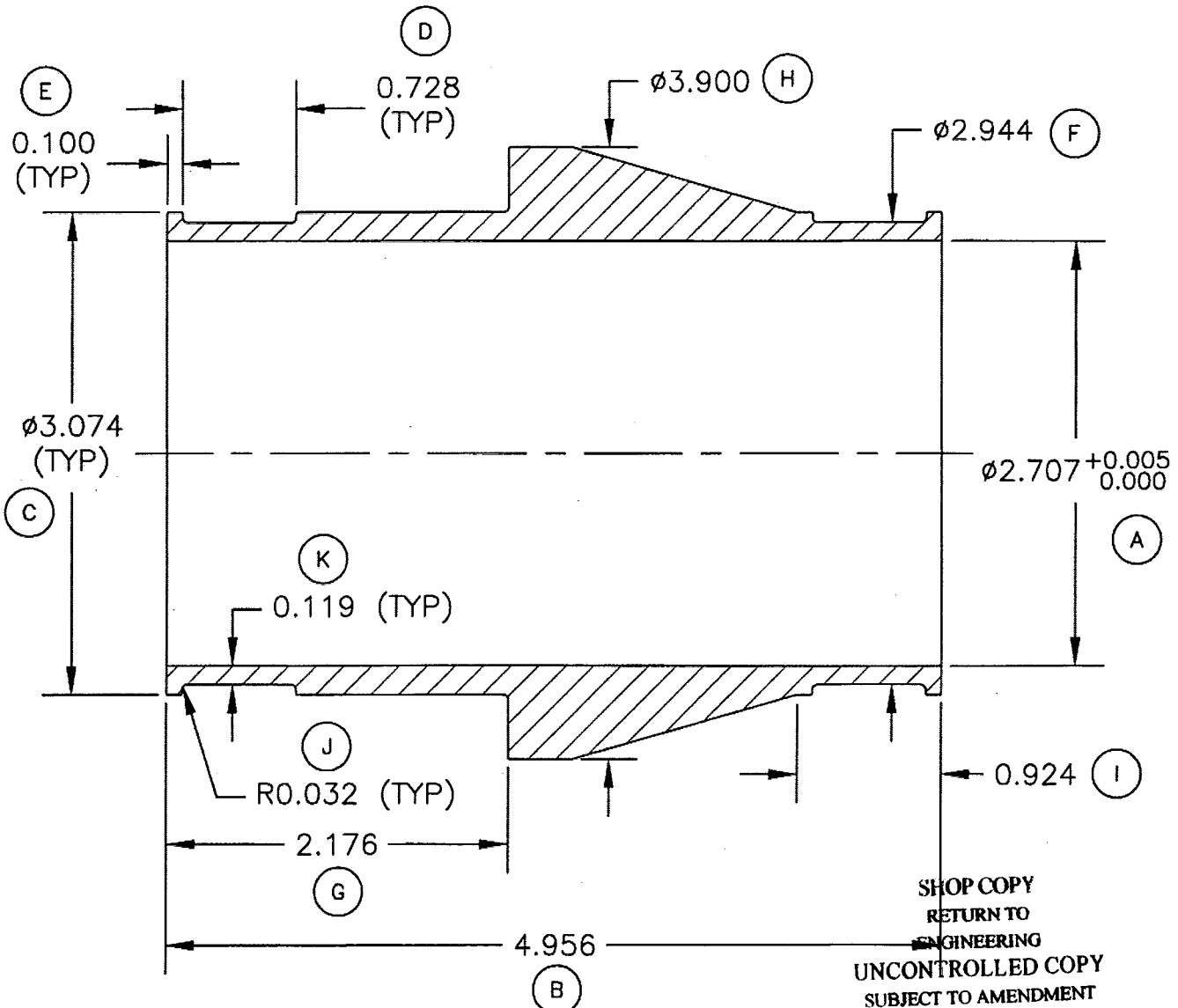
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**NOTE:** Date & initial all entries



**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	



D2893-1 TURNING DETAIL

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# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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